Work Order ID 68400

PRELIMINARY ISSUE

Tuesday, April 12, 2011 3:36:46 PM

Item ID: D4366-043 **Accept** **Setup Start**

Revision ID: PRELIM **Stop**

Item Name: Aft Wearplate Assembly

Start Date: 4/12/2011 **Start Qty:** 1.00 **Cust Item ID:**

Required Date: 4/15/2011 **Req'd Qty:** 1.00 **Customer:** POSITIVE RECALL

Reference:

Approvals: **Process Plan:** N **Date:** 11-04-12 **Tooling:** **Date:** **Run Start**

QC: **Date:** **SPC (Y/N):** **Date:** **Stop**

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
Draw Nbr: D4366 / Revision Nbr: PA1									
100		0.00							
Waterjet						IB 11-4-19			
FLOW CNC Waterjet	**Memo**	0.00							
304.050	1-Cut as per Dwg (D4366-3) Dwg Rev: PA1 Prog Rev: PA1								
	2-Deburr if necessary								
						(1)			
110	QC2- Inspect parts off machine FAI/FAIB	0.00							
QC						IB 11-4-19			
Quality Control	**Memo**	0.00							

Dart Aerospace Ltd

W/O:		WORK ORDER CHANGES					
DATE	**STEP**	**PROCEDURE CHANGE**	**By**	**Date**	**Qty**	**Approval** Chief Eng / Prod Mgr	**Approval** QC Inspector

Part No: _____ **PAR #:** _____ **Fault Category:** _____ **NCR:** Yes No **DQA:** _____ **Date:** _____

Resolution: _____ **Disposition:** _____ **QA: N/C Closed:** _____ **Date:** _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	**STEP**	**Description of NC** Section A	**Corrective Action** Section B			**Verification** Section C	**Approval** Chief Eng	**Approval** QC Inspector
			Initial Chief Eng	**Action Description** Chief Eng	**Sign & Date**			

NOTE: Date & initial all entries

Work Order ID 68400

Tuesday, April 12, 2011 3:36:46 PM

Item ID: D4366-043
Revision ID: PRELIM
Item Name: Aft Wearplate Assembly

Start Date: 4/12/2011 **Start Qty:** 1.00
Required Date: 4/15/2011 **Req'd Qty:** 1.00
Reference:

Accept **Setup Start** **Stop**

Cust Item ID:
Customer:

Run Start **Stop**

Approvals: **Process Plan:** _____ **Date:** _____ **Tooling:** _____ **Date:** _____
QC: _____ **Date:** _____ **SPC (Y/N):** _____ **Date:** _____

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
120 QC Quality Control	QC8- Inspect parts - second check **Memo**	0.00 – inspector to PA1 0.00 Dwg only Sulo4/20 (FC)							
130 Brake NC Brake NC	Form as per dwg **Memo**	0.00 0.00 SB 11/04/20				(1)			
140 QC Quality Control	QC5- Inspect part completeness to step on W/O **Memo**	0.00 – inspector to PA1 0.00 (SB) Dwg only Jn 10 4/20							

Dart Aerospace Ltd

W/O:		WORK ORDER CHANGES					
DATE	**STEP**	**PROCEDURE CHANGE**	**By**	**Date**	**Qty**	**Approval** Chief Eng / Prod Mgr	**Approval** QC Inspector

Part No: _____ **PAR #:** _____ **Fault Category:** _____ **NCR:** Yes No **DQA:** _____ **Date:** _____

Resolution: _____ **Disposition:** _____ **QA: N/C Closed:** _____ **Date:** _____

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			Initial Chief Eng	**Action Description** Chief Eng	**Sign & Date**			

NOTE: Date & initial all entries

Work Order ID 68400

Tuesday, April 12, 2011 3:36:46 PM

Item ID: D4366-043 **Accept** **Setup Start** **Stop**

Revision ID: PRELIM

Item Name: Aft Wearplate Assembly

Start Date: 4/12/2011 **Start Qty:** 1.00 **Cust Item ID:**

Required Date: 4/15/2011 **Req'd Qty:** 1.00 **Customer:**

Reference:

Run Start **Stop**

Approvals: **Process Plan:** _____ **Date:** _____ **Tooling:** _____ **Date:** _____

QC: _____ **Date:** _____ **SPC (Y/N):** _____ **Date:** _____

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
150		0.00							
Large Fab									
	Memo	0.00							
Large Fab	1- on D4367-3, fill cut outs with hardcoat welding rod as per dwg D4366 **DT9756** 2059 B Hardcoat Welding Rod BATCH#: M117730								
	2-weld D4367-3 to wearplate by positioning holes together as per dwg D4366 304 S.S. Welding Rod BATCH #: M107051								
	3-Transfer drill holes in bar								
160	QC9- Inspect visual per QSI004- Fusion Welds	0.00							
QC									
	Memo	0.00							
Quality Control									

EL 11-5-12 (X1)

11.06.13

POSITIVE RECALL

EFFECTIVE 11.04.13 AUTH

RELEASED _____ DATE _____

Dart Aerospace Ltd

W/O:		WORK ORDER CHANGES					
DATE	**STEP**	**PROCEDURE CHANGE**	**By**	**Date**	**Qty**	**Approval** Chief Eng / Prod Mgr	**Approval** QC Inspector

Part No: _____ **PAR #:** _____ **Fault Category:** _____ **NCR:** Yes No **DQA:** _____ **Date:** _____

Resolution: _____ **Disposition:** _____ **QA: N/C Closed:** _____ **Date:** _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
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			Initial Chief Eng	**Action Description** Chief Eng	**Sign & Date**			

NOTE: Date & initial all entries

Work Order ID 68400

Tuesday, April 12, 2011 3:36:46 PM

Item ID: D4366-043 **Accept** **Setup Start**

Revision ID: PRELIM **Stop**

Item Name: Aft Wearplate Assembly

Start Date: 4/12/2011 **Start Qty:** 1.00 **Cust Item ID:**

Required Date: 4/15/2011 **Req'd Qty:** 1.00 **Customer:**

Reference:

Run Start

Approvals: **Process Plan:** _____ **Date:** _____ **Tooling:** _____ **Date:** _____

Stop

QC: _____ **Date:** _____ **SPC (Y/N):** _____ **Date:** _____

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
170	QC5- Inspect part completeness to step on W/O	0.00 – inspector to PA1							
QC	**Memo**	0.00 Dwg only							
Quality Control		Outlook 13 (2)							
180		0.00							
Small Fab	**Memo**	0.00				BS 11-06-13			
Small Fab	1- After finish, coat entire top (concave) surface as per note 10 on sheet 2 dwg D4366. coat inside surface w/ Plus1 Hackguard								13 Jan 11
190	QC5- Inspect part completeness to step on W/O	0.00							
QC	**Memo**	0.00				M 11	06	13	(1)
Quality Control									

Dart Aerospace Ltd

W/O:		WORK ORDER CHANGES					
DATE	**STEP**	**PROCEDURE CHANGE**	**By**	**Date**	**Qty**	**Approval** Chief Eng / Prod Mgr	**Approval** QC Inspector

Part No: _____ **PAR #:** _____ **Fault Category:** _____ **NCR:** Yes No **DQA:** _____ **Date:** _____

Resolution: _____ **Disposition:** _____ **QA: N/C Closed:** _____ **Date:** _____

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			Initial Chief Eng	**Action Description** Chief Eng	**Sign & Date**			

NOTE: Date & initial all entries

Work Order ID 68400

Tuesday, April 12, 2011 3:36:46 PM

Item ID: D4366-043
Revision ID: PRELIM
Item Name: Aft Wearplate Assembly
Start Date: 4/12/2011 **Start Qty:** 1.00
Required Date: 4/15/2011 **Req'd Qty:** 1.00
Reference:

Accept **Setup Start** **Stop**

Cust Item ID:
Customer:

Run Start **Stop**

Approvals: **Process Plan:** _____ **Date:** _____ **Tooling:** _____ **Date:** _____
QC: _____ **Date:** _____ **SPC (Y/N):** _____ **Date:** _____

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
200	Identify as per dwg & Stock Location:_____	0.00							
Packaging	**Memo**	0.00				_____	_____	_____	_____
Packaging									
210	QC21- Final Inspection - Work Order Release	0.00							
QC	**Memo**	0.00				_____	_____	_____	_____
Quality Control									

RD2382 MK 11-06-23

Dart Aerospace Ltd

W/O:		WORK ORDER CHANGES					
DATE	**STEP**	**PROCEDURE CHANGE**	**By**	**Date**	**Qty**	**Approval** Chief Eng / Prod Mgr	**Approval** QC Inspector

Part No: _____ **PAR #:** _____ **Fault Category:** _____ **NCR:** Yes No **DQA:** _____ **Date:** _____

Resolution: _____ **Disposition:** _____ **QA: N/C Closed:** _____ **Date:** _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	**STEP**	**Description of NC** Section A	**Corrective Action** Section B			**Verification** Section C	**Approval** Chief Eng	**Approval** QC Inspector
			Initial Chief Eng	**Action Description** Chief Eng	**Sign & Date**			

NOTE: Date & initial all entries

Picklist Print

Tuesday, April 12, 2011 3:36:51 PM

Work Order ID: 68400

Parent Item: D4366-043

Parent Item Name: Aft Wearplate Assembly

Start Date: 4/12/2011 **Required Date:** 4/15/2011

Start Qty: 1.00 **Required Qty:** 1.00

Comments: IPP Rev:A 11.04.12 new issue DD verf:EC

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Qty per Kit	Total Qty	Qty Issued	Date Issued	Status
M304S18GA		Purchased	No			100	sf	204.0000	3.369	3.546316			
304/316 .050 Sheet										IB 11-4-19			

Location	Loc Qty	Loc Code	
MAT020	204		(1)
111743	1		
112178	4		
113062	18		
116135	48		116135
116604	37		
116979	96		

D4367-3		Manufactured	No			150	Each	0.0000	1	1			
Bar										EC 11-5-12			

~~68402~~

68402 x1

Dart Aerospace Ltd

W/O:		WORK ORDER CHANGES					
DATE	**STEP**	**PROCEDURE CHANGE**	**By**	**Date**	**Qty**	**Approval** Chief Eng / Prod Mgr	**Approval** QC Inspector

Part No: _____ **PAR #:** _____ **Fault Category:** _____ **NCR:** Yes No **DQA:** _____ **Date:** _____

Resolution: _____ **Disposition:** _____ **QA: N/C Closed:** _____ **Date:** _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	**STEP**	**Description of NC** Section A	**Corrective Action** Section B			**Verification** Section C	**Approval** Chief Eng	**Approval** QC Inspector
			Initial Chief Eng	**Action Description** Chief Eng	**Sign & Date**			

NOTE: Date & initial all entries

DART AEROSPACE LTD	Work Order:	68400
Description: AFT WEAR PLATE ASSEMBLY	Part Number:	D4366-043
Inspection Dwg: D4366-3 . Rev: pA1		Page 1 of 1

FIRST ARTICLE INSPECTION CHECKLIST

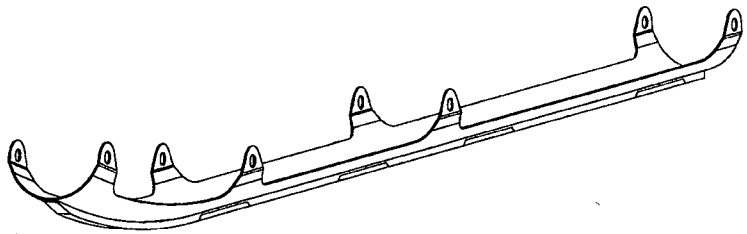
[X] First Article [X] Prototype

Drawing Dimension	Tolerance	Actual Dimension	Accept	Reject	Method of Inspection	Comments
.400	+/- .010	.403	X		V HBOZ	
.875	+/- .010	.875	X		V	
.125	+/- .010	.128	X		V	
3.00	+/- .030	3.009	X		V	
3.50	+/- .030	3.504	X		V	
3.70	+/- .030	3.70	X		V	
.75	+/- .030	.75	X		V	
9.00	+/- .030	9.00	X		T PBOI	
40.144	+/- .010	40.144	X		T	
61.000	+/- .010	61.00	X		T	
5.320	+/- .010	5.312	X		V	
4.00	+/- .030	3.996	X		V	
Ø .188	+.005 -.001	.192	X		V	
20.225	+/- .010	20.225	X		T	
38.175	+/- .010	38.175	X		T	
61.350	+/- .010	61.350	X		T	
76.800	+/- .010	76.800	X		T	
80.86	+/- .030	80.86	X		T	
.050	+/- .010	.047	X		V	

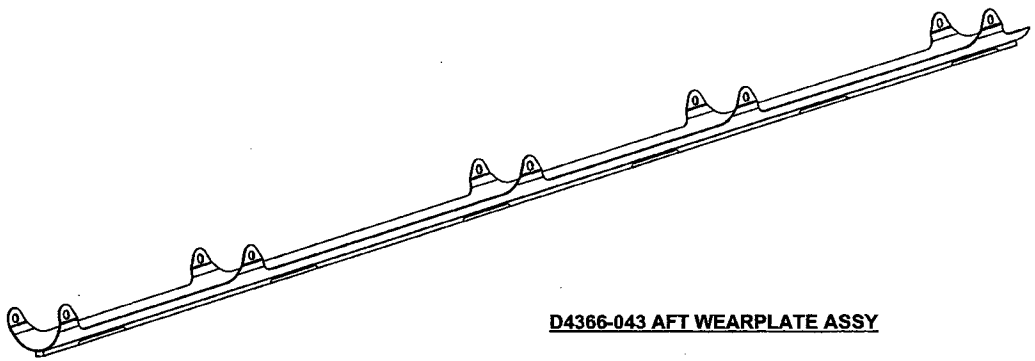
Measured by:	MB	Audited by:	S	Prototype Approval:	
Date:	11-4-14	Date:	11/04/14	Date:	

Rev	Date	Change	Revised by	Approved
A		New Issue	KJ/JLM	

ITEM	QTY -041	QTY -043	PART NUMBER	DESCRIPTION
	X		D4366-041	FWD WEARPLATE ASSY
		X	D4366-043	AFT WEARPLATE ASSY
1	1		D4366-1	PLATE
2		1	D4366-3	PLATE
3	1		D4367-1	BAR
4		1	D4367-3	BAR
5	A/R	A/R	2059B	HARDCOAT
6	A/R	A/R	ROCKGUARD 4714	SEALANT



D4366-041 FWD WEARPLATE ASSY



D4366-043 AFT WEARPLATE ASSY

SHOP COPY
RETURN TO
ENGINEERING
UNCONTROLLED COPY
SUBJECT TO AMENDMENT
WITHOUT NOTICE
WORK ORDER
NO. 84100
11-04-12
PRELIMINARY ISSUE

REV.	DESCRIPTION	BY	DATE
PA1	NEW ISSUE	SC	11.03.24

DESIGN	SC	DART AEROSPACE USA, INC. PORT HADLOCK, WA
DRAWN	SC	
CHECKED		DRAWING NO. D4366 REV. PA1
MFG. APPR.		SHEET 1 OF 5
APPROVED		TITLE WEARPLATE ASSY SCALE NTS
DE APPR.		
DATE	11.03.24	

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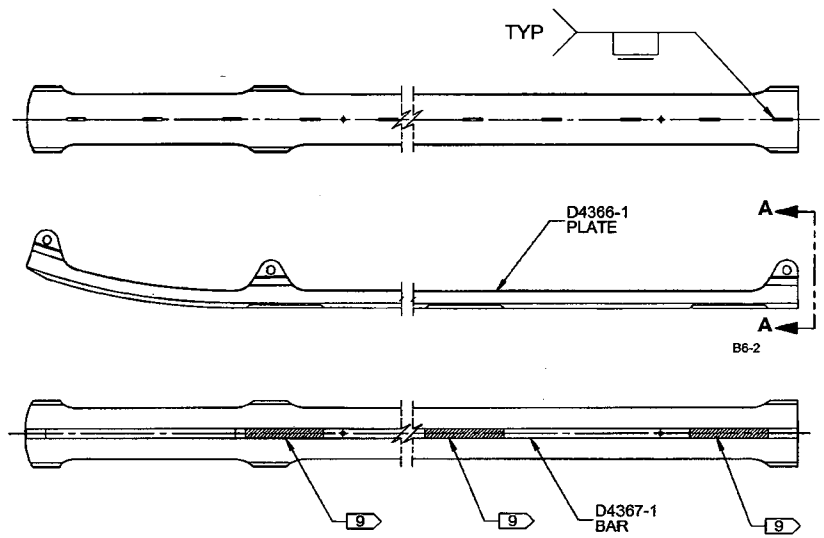
W/O:		WORK ORDER CHANGES					
DATE	**STEP**	**PROCEDURE CHANGE**	**By**	**Date**	**Qty**	**Approval** Chief Eng / Prod Mgr	**Approval** QC Inspector

Part No: _____ **PAR #:** _____ **Fault Category:** _____ **NCR:** Yes No **DQA:** _____ **Date:** _____

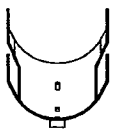
Resolution: _____ **Disposition:** _____ **QA: N/C Closed:** _____ **Date:** _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	**STEP**	**Description of NC** Section A	**Corrective Action** Section B			**Verification** Section C	**Approval** Chief Eng	**Approval** QC Inspector
			Initial Chief Eng	**Action Description** Chief Eng	**Sign & Date**			

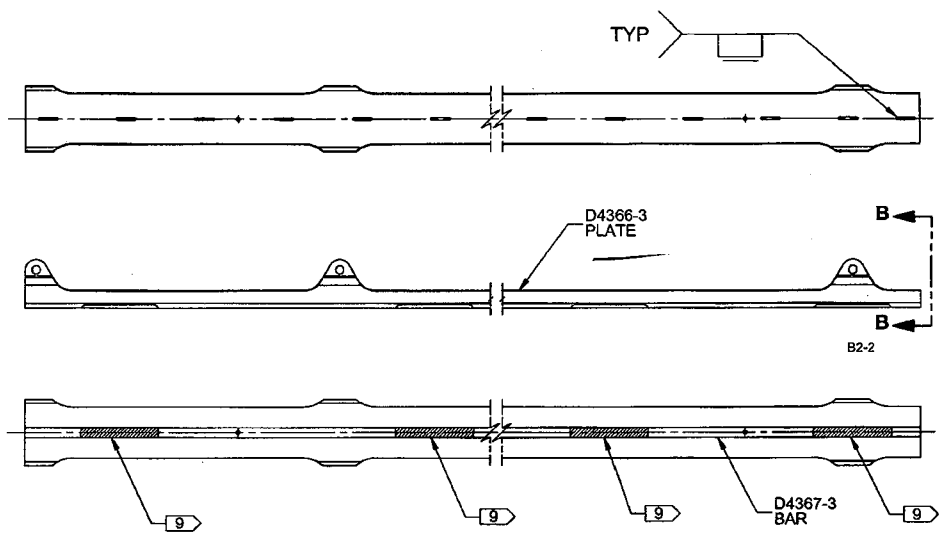
NOTE: Date & initial all entries



D4366-041 FWD WEARPLATE ASSY



VIEW A-A C5-2



D4366-043 AFT WEARPLATE ASSY



VIEW B-B C1-2

B/L w/o 68100

PRELIMINARY ISSUE

NOTES:
1) MATERIAL: N/A
2) FINISH: NONE
3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
4) UNITS: INCHES UNLESS OTHERWISE NOTED
5) BREAK SHARP EDGES: N/A
6) IDENTIFICATION: IDENTIFY WITH DART P/N "D4366-04X" PER QSI 044 6.1
7) WEIGHT: D4366-041 = 4.80 lbs; D4366-043 = 7.49 lbs
8) WELDING: PER QSI 004
9) 2059B HARDCOAT WELD, 0.19 THICK X 0.50 WIDE, FLUSH WITH D4367-X BAR ON ALL 3 SURFACES
10) AFTER FINISH, COAT ENTIRE TOP (CONCAVE) SURFACE WITH A LAYER OF SIKAFLEX-241/-291 OR PROSEAL 890 OR PROSEAL 1422 OR MIL-S-8802 CLASS B SEALANT OR PLUS ONE ROCKGUARD 4714, 0.020-0.040 THICK

DESIGN	SC	**DART AEROSPACE USA, INC.** PORT HADLOCK, WA
DRAWN	SC	
CHECKED		DRAWING NO. D4366 REV. PA1
MFG. APPR.		SHEET 2 OF 5
APPROVED		TITLE WEARPLATE ASSY SCALE NTS
DE APPR.		
DATE	11.03.24	

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Dart Aerospace Ltd

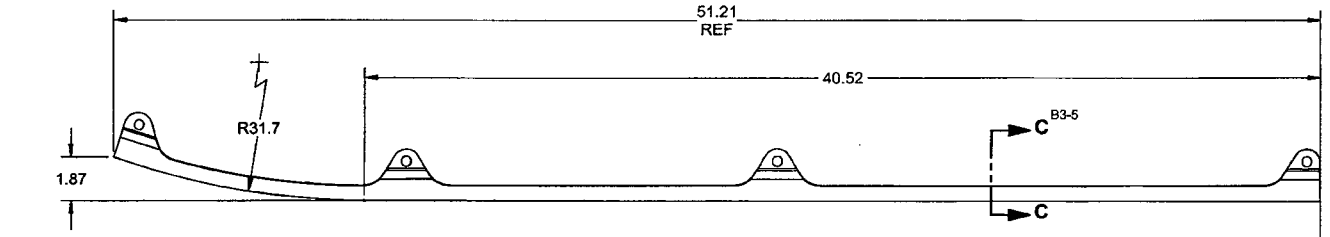
W/O:		WORK ORDER CHANGES					
DATE	**STEP**	**PROCEDURE CHANGE**	**By**	**Date**	**Qty**	**Approval** Chief Eng / Prod Mgr	**Approval** QC Inspector

Part No: _____ **PAR #:** _____ **Fault Category:** _____ **NCR:** Yes No **DQA:** _____ **Date:** _____

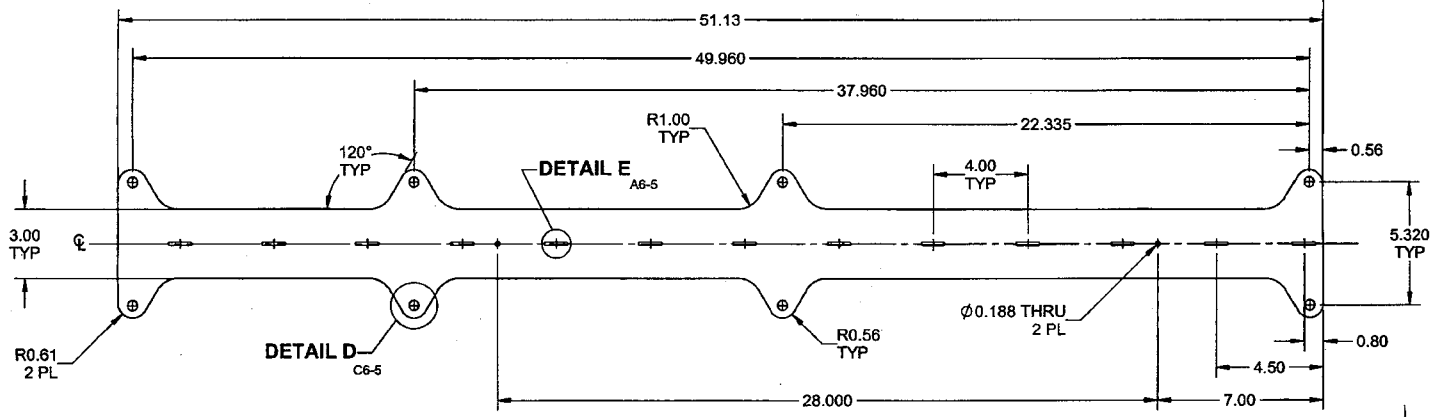
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			Initial Chief Eng	**Action Description** Chief Eng	**Sign & Date**			

NOTE: Date & initial all entries



D4366-1 PLATE
(MAKE FROM D4366-1F)



D4366-1F PLATE

w/o 68400

NOTES:
1) MATERIAL: AISI 304/316 STAINLESS STEEL SHEET PER AMS 5513 OR 5524
OR ASTM A240 OR ASME SA240
18 GAUGE (0.050 THICK), REF. DART SPEC. M304S18GA
2) FINISH: NONE
3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
4) UNITS: INCHES UNLESS OTHERWISE NOTED
5) BREAK SHARP EDGES: 0.005 TO 0.010 MAX
6) IDENTIFICATION: N/A
7) WEIGHT: 2.45 lbs

PRELIMINARY ISSUE

DESIGN	SC
DRAWN	SC
CHECKED	
MFG. APPR.	
APPROVED	
DE APPR.	
DATE	11.03.24

DART AEROSPACE USA, INC.
PORT HADLOCK, WA

DRAWING NO. D4366 REV. PA1
SHEET 3 OF 5
TITLE WEARPLATE ASSY
SCALE NTS

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Dart Aerospace Ltd

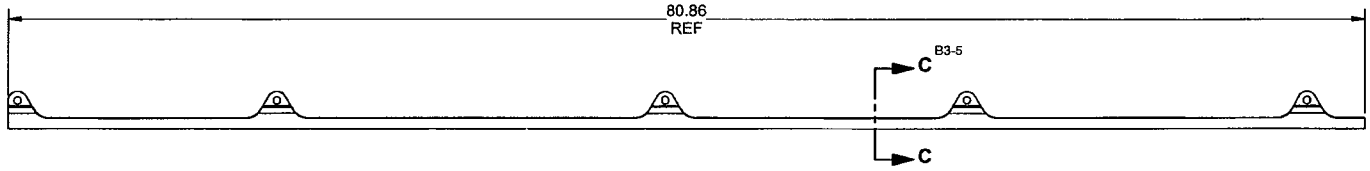
W/O:		WORK ORDER CHANGES					
DATE	**STEP**	**PROCEDURE CHANGE**	**By**	**Date**	**Qty**	**Approval** Chief Eng / Prod Mgr	**Approval** QC Inspector

Part No: _____ **PAR #:** _____ **Fault Category:** _____ **NCR:** Yes No **DQA:** _____ **Date:** _____

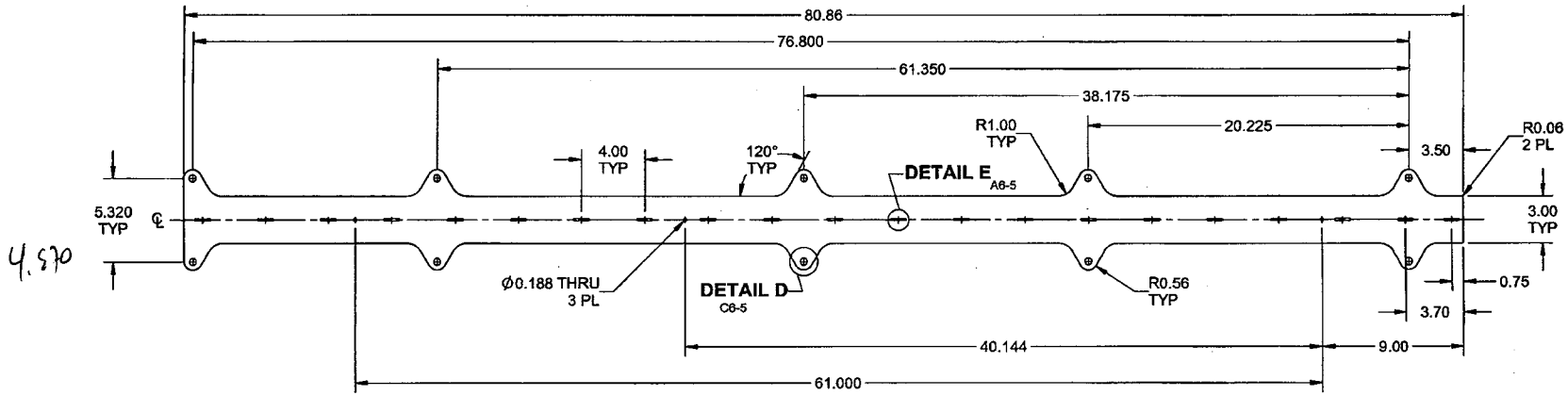
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			Initial Chief Eng	**Action Description** Chief Eng	**Sign & Date**			

NOTE: Date & initial all entries



D4366-3 PLATE
(MAKE FROM D4366-3F)



D4366-3F PLATE

w/o 68400

PRELIMINARY ISSUE

NOTES:
1) MATERIAL: AISI 304/316 STAINLESS STEEL SHEET PER AMS 5513 OR 5524
OR ASTM A240 OR ASME SA240
18 GAUGE (0.050 THICK), REF. DART SPEC. M304S18GA
2) FINISH: NONE
3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
4) UNITS: INCHES UNLESS OTHERWISE NOTED
5) BREAK SHARP EDGES: 0.005 TO 0.010 MAX
6) IDENTIFICATION: N/A
7) WEIGHT: 3.80 lbs

DESIGN	SC	**DART AEROSPACE USA, INC.** PORT HADLOCK, WA
DRAWN	SC	DRAWING NO. D4366 — REV. PA1 — SHEET 4 OF 5
CHECKED		
MFG. APPR.		
APPROVED		TITLE: WEARPLATE ASSY — SCALE: NTS
DE APPR.		
DATE	11.03.24	

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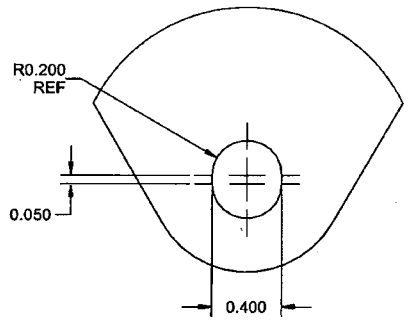
W/O:		WORK ORDER CHANGES					
DATE	**STEP**	**PROCEDURE CHANGE**	**By**	**Date**	**Qty**	**Approval** Chief Eng / Prod Mgr	**Approval** QC Inspector

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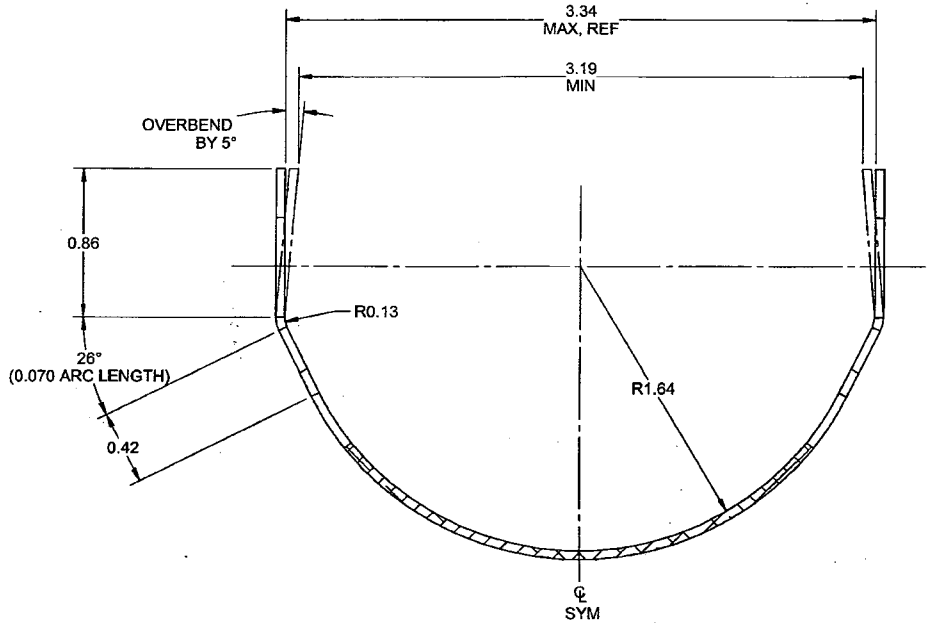
Resolution: _____ **Disposition:** _____ **QA: N/C Closed:** _____ **Date:** _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	**STEP**	**Description of NC** Section A	**Corrective Action** Section B			**Verification** Section C	**Approval** Chief Eng	**Approval** QC Inspector
			Initial Chief Eng	**Action Description** Chief Eng	**Sign & Date**			

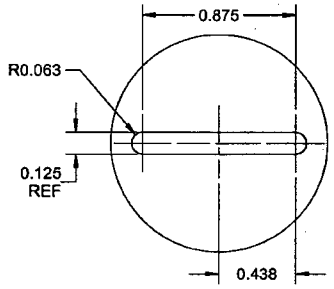
NOTE: Date & initial all entries



DETAIL D
SLOT DETAIL TYP
B6-3
B5-4



SECTION C-C
D3-3
D3-4



DETAIL E
SLOT DETAIL TYP
B5-3
B3-4

w/o 68400

PRELIMINARY ISSUE

DESIGN	SC	**DART AEROSPACE USA, INC.**	
DRAWN	SC	PORT HADLOCK, WA	
CHECKED		DRAWING NO.	REV. PA1
MFG. APPR.		D4366	SHEET 5 OF 5
APPROVED		TITLE	SCALE
DE APPR.		WEARPLATE ASSY	NTS
DATE	11.03.24		

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Dart Aerospace Ltd

W/O:		WORK ORDER CHANGES					
DATE	**STEP**	**PROCEDURE CHANGE**	**By**	**Date**	**Qty**	**Approval** Chief Eng / Prod Mgr	**Approval** QC Inspector

Part No: _____ **PAR #:** _____ **Fault Category:** _____ **NCR:** Yes No **DQA:** _____ **Date:** _____

Resolution: _____ **Disposition:** _____ **QA: N/C Closed:** _____ **Date:** _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	**STEP**	**Description of NC** Section A	**Corrective Action** Section B			**Verification** Section C	**Approval** Chief Eng	**Approval** QC Inspector
			Initial Chief Eng	**Action Description** Chief Eng	**Sign & Date**			

NOTE: Date & initial all entries